

Work Order ID 76394

November-11-11 12:46:46 PM

76394

Page 1

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 11/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 25/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 11/11/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	Rev H U/R/DEO

Rev. I 11.11.11

100 MORI SEIKI CNC LATHE LARGE 0.00
100
 Mori Seiki Memo 0.00
 Mori Seiki CNC Lathe Large Turn as per Folio FA599 Rev: 1 & Dwg. D3391 Rev: 1
 scribe batch # on fwd end at 90 degree

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

111 QC8- Inspect parts - second check 0.00
111
 QC Memo 0.00
 Quality Control

11/11/15
 11/11/15
 11.11.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/11/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 25/11/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160		0.00							
160	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170		0.00							
170	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

25 11-11-22

25 11-11-22 (1)

11-11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Tube Assembly

Start Date: 11/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391 (Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878 (Mid Tube) & DT8217 Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297" and float bag holes to 0.328" as per Dwg D3391.

7-Deburr

3 OK 11/11/23

3 OK 11/11/24

DP 11-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Tube Assembly

Start Date: 11/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00

200

HandFinish

Memo

0.00

Hand Finishing

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

S. 11/12/13

DP 11-12-13

1 0 BE11-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Reference:

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	Skidtubes					①			
Skidtubes	Memo	0.00							
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>m117820</u> exp. date: <u>03/2012</u> cure time 12hrs as per QSI0015								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									
235	Pressure Wash per QSI005 4.3	0.00							
235									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

SAD 11-12-13

8/11/12

① 11-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240									
Powdercoat									
Powder Coating									
	Memo	0.00							
	START TIME: 10-00								
	OVEN TEMPERATURE: 320 °C								
	FINISH TIME: 10-30								
250	QC3- Inspect Part Finish	0.00							
250									
QC									
Quality Control									
	Memo	0.00							
260	HandFinishing	0.00							
260									
HandFinish									
Hand Finishing									
	Memo	0.00							
	1-Install inserts as per Dwg D3391								
	2-Install Aft Cap as per Dwg D3391								
	A/R Sikaflex-241/-291 11119443								
	Sikaflex expiry date: 12/01								

1 X M-1 11/12/17

1 d M 11/12/21

1 p M 11/12/21

M119480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							
270		0.00							
QC	Memo								
Quality Control									
280	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
280		0.00							
Packaging	Memo								
Packaging									
290	QC21- Final Inspection - Work Order Release	0.00							
290		0.00							
QC	Memo								
Quality Control									

11/12/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 76394

76394

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090		Manufactured	No			100	Each	17.0000	1	1			

D6014-090

ALUMINUM EXTRUSION

**

Location

Loc Qty

Loc Code

LG

17

66179

17

D3670-4-200

Manufactured No

230

Each

104.0000

4

4

D3670-4-200

SPACER

**

Location

Loc Qty

Loc Code

LG

12

71850

12

LG001

92

72851

92

mm-v 11/11/14

SAP 12-12-13

(J)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 76394

76394

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270 Each

243.0000 1 1

D2646

Aft Cap

**

B73825 (x1) M 11/12/11

Location

Loc Qty

Loc Code

FP002

226

73294

26

73825

200

FP004

5

68280

5

FP006

5

62678

5

FP-4

3

70945

1

71070

2

fp5

4

71038

4

D3537-1

Manufactured No

270 Each

90.0000 1 1

D3537-1

Wearpad

**

B77436 (x1) M 11/12/11

D4095-049

Location

Loc Qty

Loc Code

FP002

83

74436

56

74597

27

FP017

7

69817

5

70686

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 76394

76394

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-7

Manufactured No

270

Each

19.0000

1

1

~~*D3537-7*~~

Wearpad

**

1376537 (v1) Jul 11/21

D-1095-0-17

Q 11.12.21

Location

Loc Qty

Loc Code

FP

4

71689

4

FP001

12

74617

12

FP017

3

71689

3

D3553-1

Manufactured No

270

Each

35.0000

1

1

~~*D3553-1*~~

Gasket

**

N/A

N/A Q 11.12.21

Location

Loc Qty

Loc Code

FP013

35

56568

2

73155

33

D3553-3

Manufactured No

270

Each

20.0000

1

1

~~*D3553-3*~~

Gasket

**

N/A

N/A Q 11.12.21

Location

Loc Qty

Loc Code

FP

20

31631

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270 Each

688.0000

2

2

D3672-1

Phenolic Washer

**

11/12/21

Location

Loc Qty

Loc Code

FP-A

424

52505

0

66821

424

v2

ST074

264

72229

264

ALS4-1032-130

Purchased

No

260

Each

2,000.000

14

14

AI S4-1032-130

Insert

ALS4-1032-130

**

11/19/30 (v14) 11/12/21

Location

Loc Qty

Loc Code

ST280

1984

119084

1984

ST281

16

117717

2

118237

12

118312

2

ALS4-1032-225

Purchased

No

270

Each

2,181.000

12

12

AI S4-1032-225

Insert

**

11/12/21

Location

Loc Qty

Loc Code

ST281

2181

108696

285

110768

62

118386

858

118966

976

x12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Aft Tube Assembly

Start Date: 11/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

270 Each 2,163.000 6 6

AN3C4A

BOLT

**

21 11/12/21

Location

Loc Qty

Loc Code

ST350

2163

117313

2

117688

5

117872

22

118112

16

118451

2

118706

142

118838

974

119328

1000

✓6

AN3C5A Purchased No

270 Each 987.0000 4 4

AN3C5A

Bolt

**

21 119749 (x4) 21 11/12/21

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

980

116419

28

117343

17

117764

166

117872

2

118451

267

119127

500

AN960C10L NAS1149C0332 Purchased No

270 Each 0.0000 10 10

***AN960C10I ***

washer

**

21 119736 (x10) 21 11/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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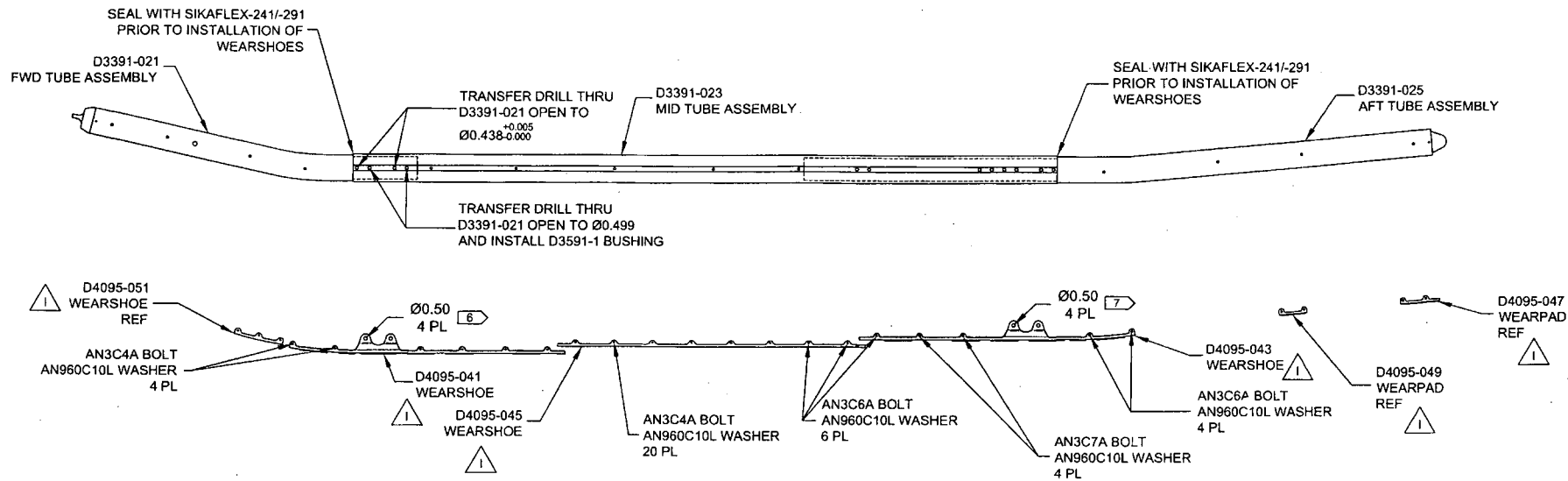
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D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

76394

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2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.	NS	D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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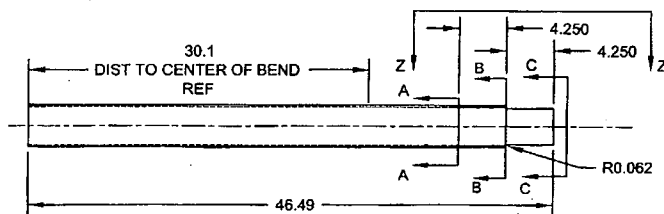
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

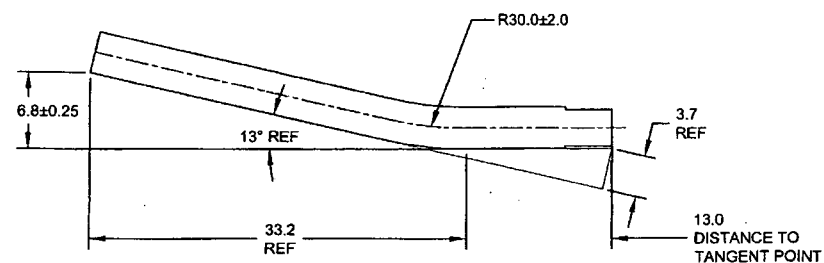
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

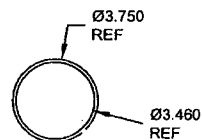
NOTE: Date & initial all entries



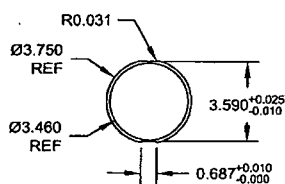
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



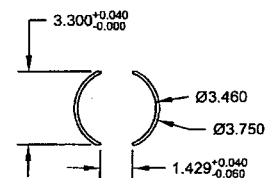
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



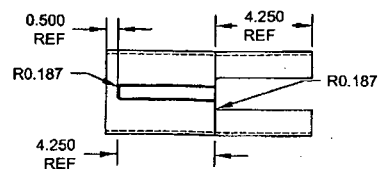
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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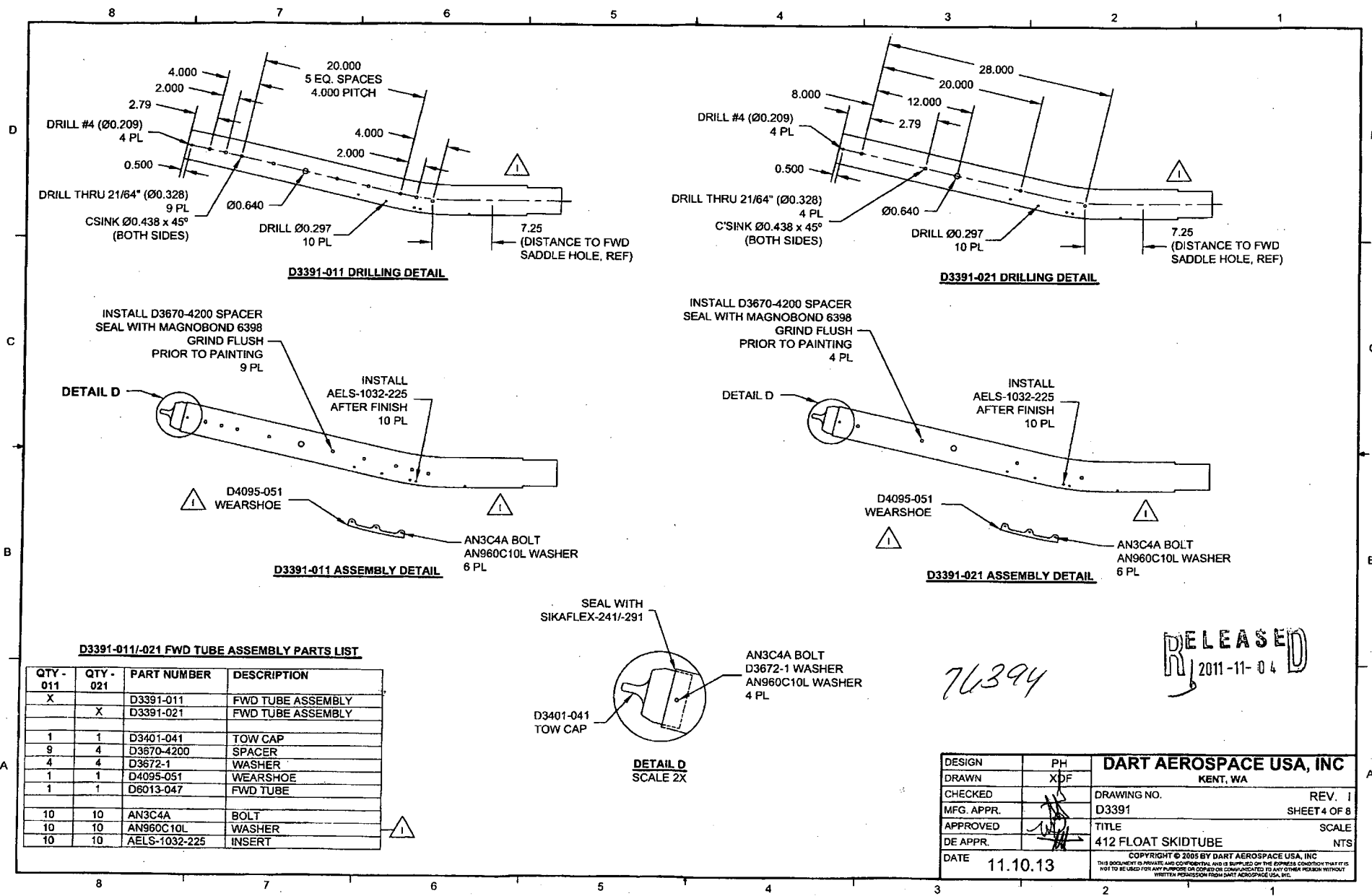
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



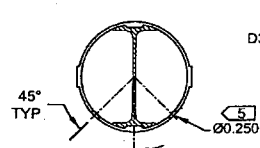
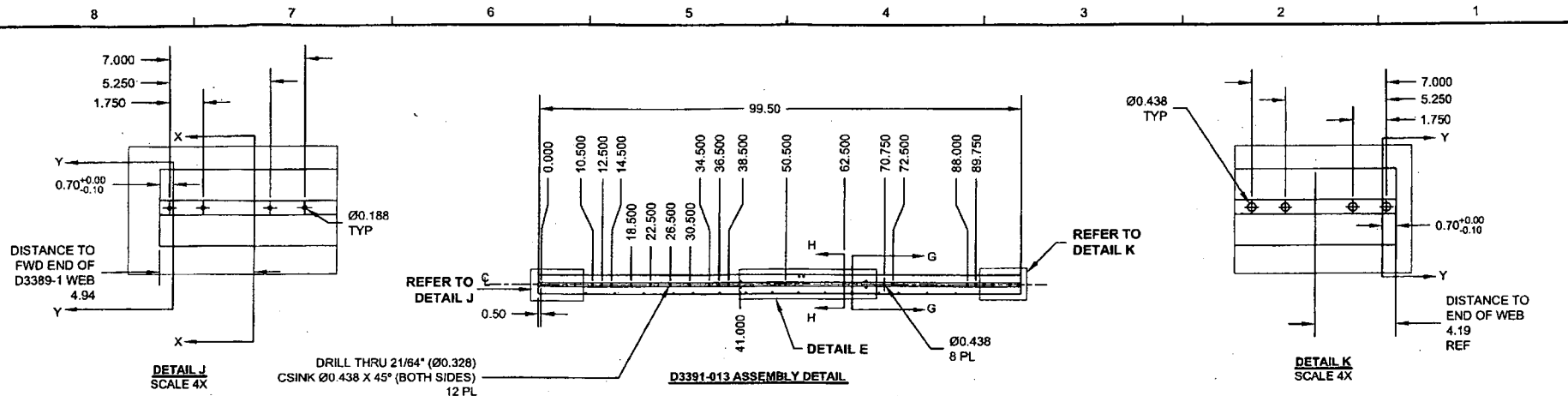
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

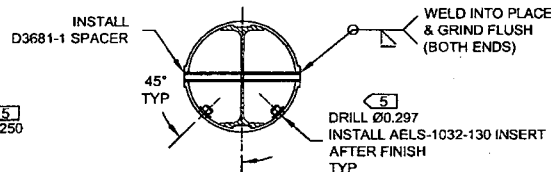
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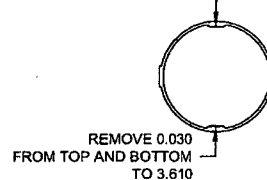
NOTE: Date & initial all entries



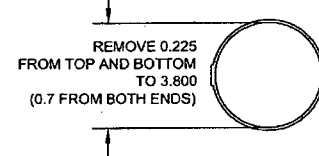
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



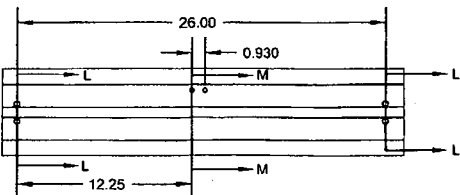
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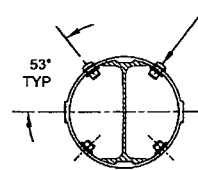
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

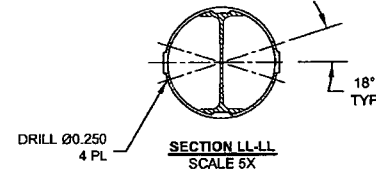
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	ALS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



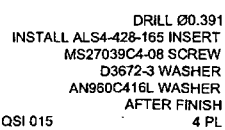
DETAIL E
SCALE NONE



SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X



SECTION L-L
SCALE 5X

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MFG. APPR.	JD	D3391	SHEET 5 OF 8
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- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

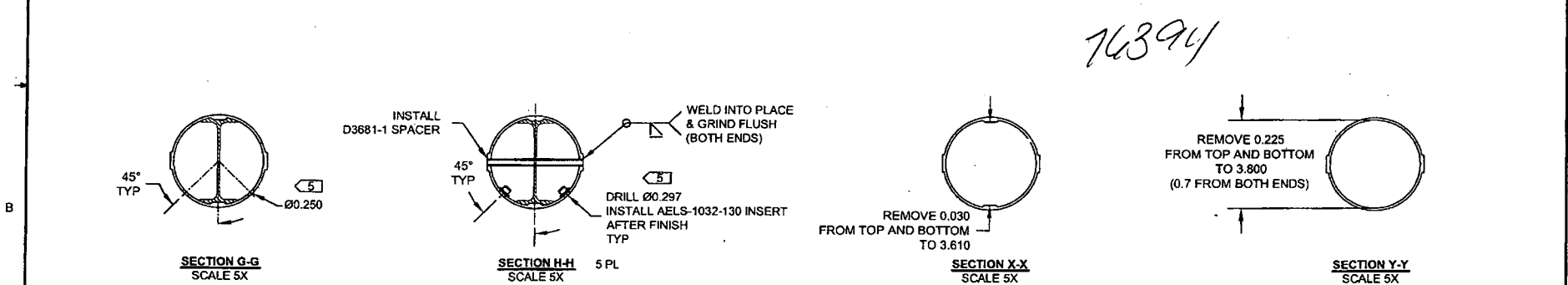
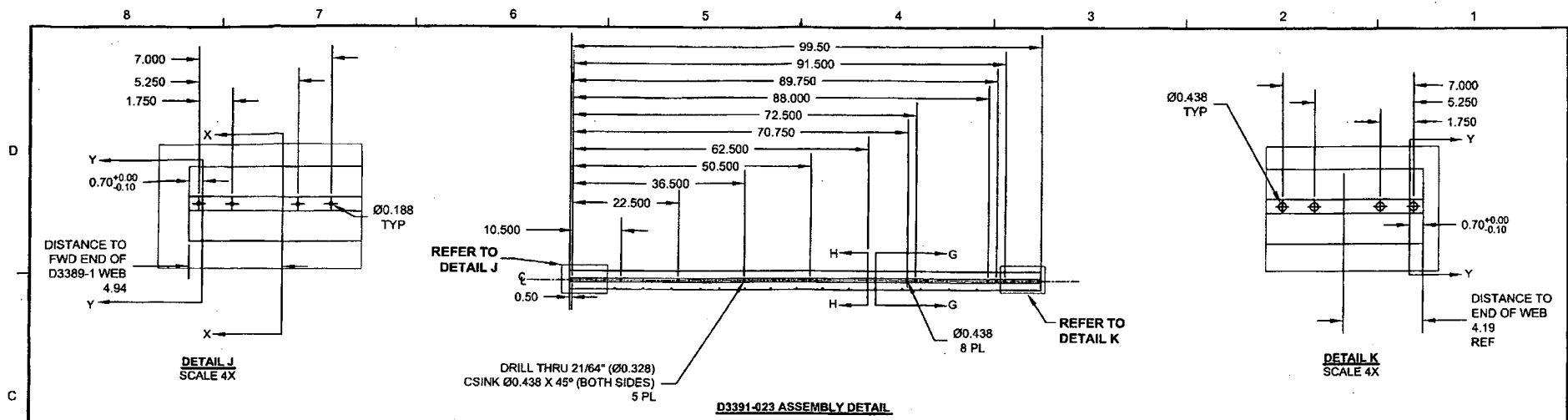
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
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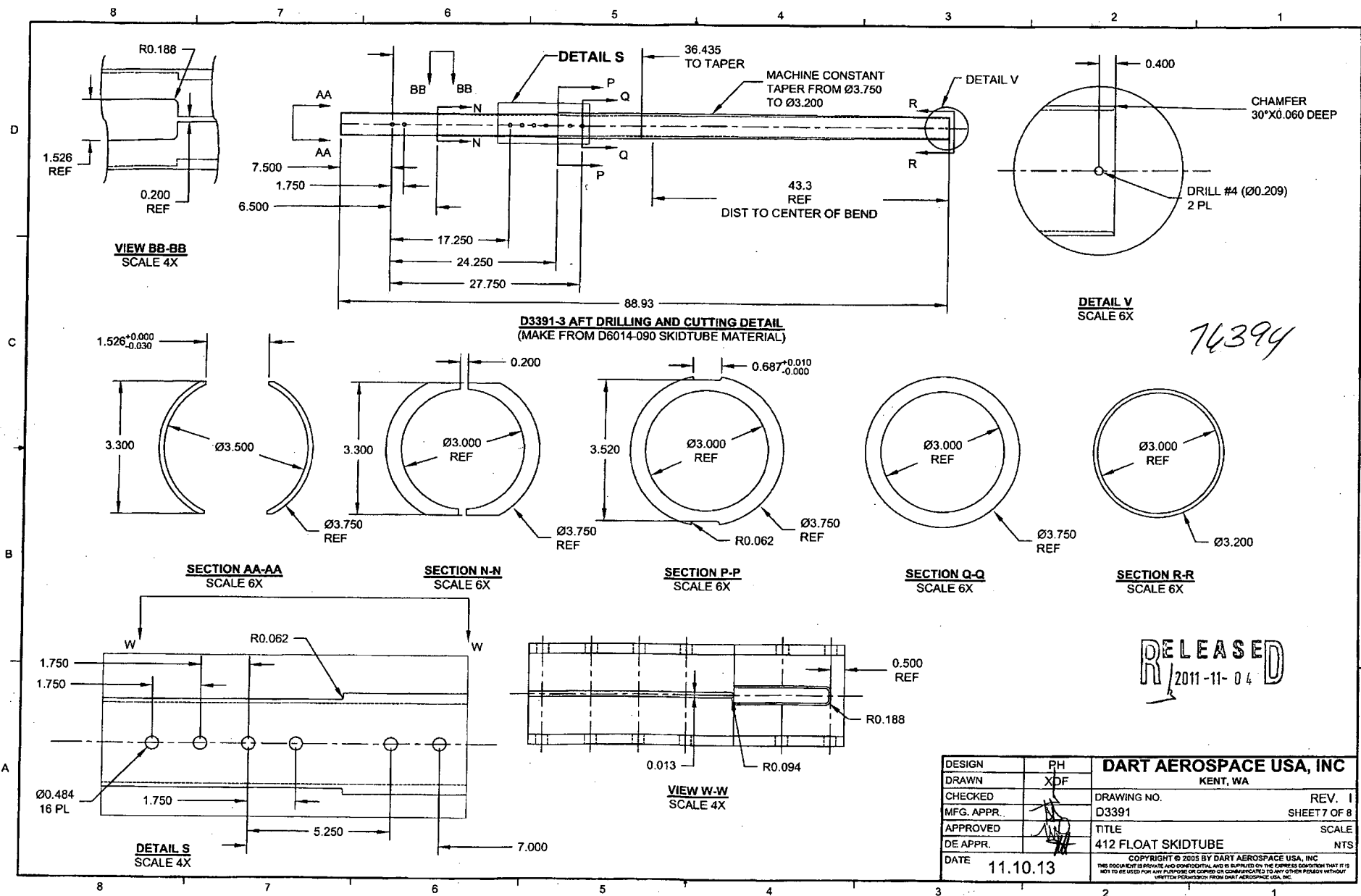
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



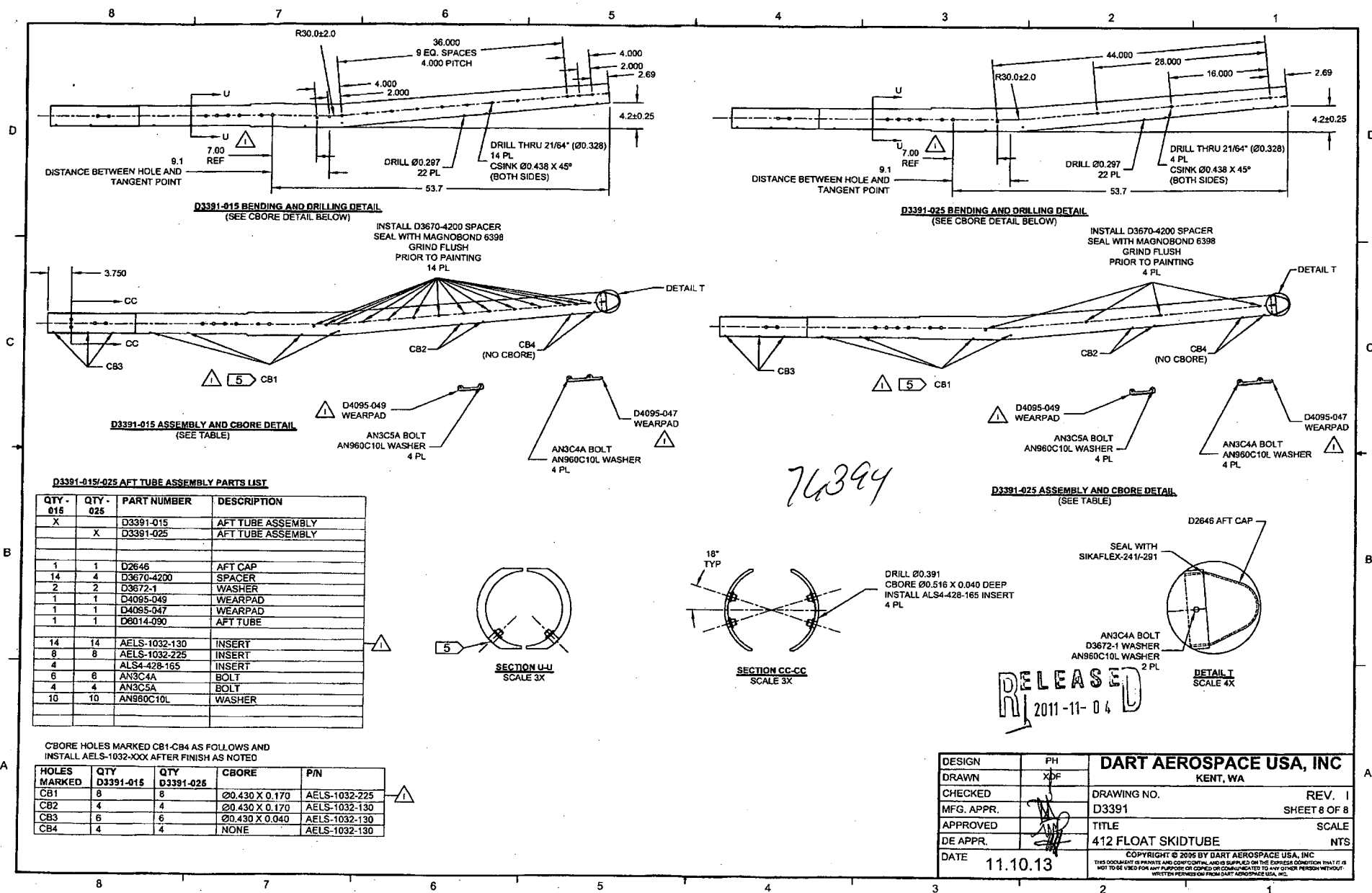
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76394
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		tape	MM6002
3.500	+/-0.010	3.500	✓		vern	CNC-08
88.93	+/-0.030	88.936	✓		tape	MAN.L-02
Ø3.200	+/-0.010	3.200	✓		vern	CNC-08
88.93	+/-0.030	88.936	✓		tape	MAN.L-02
Ø3.750	+/-0.010	3.750			vern	CNC-08
30° x 160° chamfer	+/-0.010	30° x 160	✓		11	

Measured by: MM.L

Date: 11/11/15

Audited by: RE

Date: 11-11-21

HAAS Section						
1.526	+0.000/-0.030	1.511	✓		Vern	ILM 06
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.305	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.525	✓			
0.687	+0.010/-0.000	.690	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.484	✓			

Measured by: SC.R

Date: 11-11-21

Audited by: RE

Date: 11-11-21

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	

